

Work Order ID 121547

Thursday, June 26, 2014 3:02:56 PM

121547

Page 1

Item ID: D4805-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: End Fitting
 Start Date: 6/26/14 Start Qty: ~~24.00~~ ***24*** Cust Item ID:
 Required Date: 6/26/14 Req'd Qty: ~~24.00~~ ***24*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-06-30 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4805	REV A

100 0.00

100 CG 14/07/08 24
 Outsource5

Outsource process - Machining
 Memo
 ISSUE P/O: 24906
 POSSIBLE SUPPLIER:ATG

C OF C IS REQUIRED

110 QC6- Inspect dimensions to drawing 0.00

110 (16) DAS
 QC 38
 9-89

Quality Control

DEC 16 2014

150 0.00

150 CG 14/07/08
 Purchasing

Purchasing
 Purchasing

Memo
 Issue P/O: 24906
 LPI Per ASTM 1417 LEVEL 2
 Certificate of conformaty is required
done @ ATG

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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121547

Page 2

Item ID: D4805-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: End Fitting

Start Date: 6/26/14

Start Qty: 24.00

24

Cust Item ID:

Required Date: 6/26/14

Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Receive & Inspect for Damage & Mat'l Certs

0.00

160

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

16x SP14-12-16

16x DAS
06
8-09 DEC 17 2014

14/12/18 JG

14-12-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
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FAULT CATEGORY

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Picklist Print

July-31-14 11:22:31 AM

Page 1

Work Order ID: 121547

121547

Parent Item: D4805-5

D4805-5

Parent Item Name: End Fitting

Start Date: 6/26/14

Required Date: 6/26/14

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE JLM 14-01-28 VERIFIED BY:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4805-5P		Purchased	No				Each	0.0000		16			
D4805-5P									**				
End Fitting													
M174PH-H900R1.375		Purchased	No				f	15.6000		6			
M174PH-H900R1 375									**				
17-4 SS H900 ROUND BAR 1.375													

16x SPL4-12-16

CD 14/07/08

Location

Loc Qty

Loc Code

MAT031

15.6

m126952

15.6

6



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24906

Purchase Order Date 7/8/2014

PO Print Date 8/20/2014

Page Number 5 of 8

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Total: \$1,960.00

D4885-5P

End Fitting

12/19/2014 FN

5.00

\$166.50

\$8.00

Yes

Each

12/19/2014

AS PER DWG D4885-5 REV. A
B121407
MAT: 174PH-H900R 2" M128314

Line Total: \$832.50

D4885-7P

End Fitting

12/19/2014 FN

10.00

\$138.50

\$1.38

Yes

Each

12/19/2014

AS PER DWG D4885-7 REV. A
B121442
MAT: 174PH-H900R 2" M128809

Line Total: \$1,385.00

D4805-5P

End Fitting

12/19/2014 FN

16.00

\$147.00

\$2.35

Yes

Each

12/19/2014

AS OPER DWG D4805-5 REV. A
B121547

SP14-12-16

Note:

8/20/2014



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 909316

Date: 16-Dec-14

To

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ship To

CHANTAL LAVOIE
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
24 ea	Part: D4870-1P END FITTING, SMALL Job: 16636	PO: PO24906	Rev: A Line: 1
16 ea	Part: D4805-5P END FITTING Job: 16649	PO: PO24906	Rev: A Line: 14
18 ea	Part: D4869-3P END FITTING, EYE Job: 16650	PO: PO24906	Rev: A Line: 15
30 ea	Part: D4805-3P END FITTING Job: 16652	PO: PO24906	Rev: A Line: 17
10 ea	Part: D4808-1P ROD END Job: 16653	PO: PO24906	Rev: A Line: 18
24 ea	Part: D4869-1P END FITTING, EYE Job: 16654	PO: PO24906	Rev: A Line: 19
24 ea	Part: D4870-3P END FITTING, LARGE Job: 16637	PO: PO24906	Rev: A Line: 2
29 ea	Part: D4871-1P END FITTING Job: 16638	PO: PO24906	Rev: A Line: 3
30	Part: D4871-3P		Rev: A



F.A.I.

First Article Inspection Report

#

534


Requesting Company:	Dart Aerospace	PO#:	PO24906	Line:	14	Qty:	16
Part Number:	D4805-5P	Rev:	A	Part Description:	End Fitting		
FAI Supplied by:	A.T.G. Industries Inc.	FAI Prepared by:	Emily Louis-Seize	Date:	July 14, 2014		
Qty Inspected:	16	FAI Inspected by:	Mike Csontos	Date:	December 14, 2014		

Material and/or Special Processes

Type	Description	Specification Number/Code	Certificate of Conformance Number:
Material	17-4SS H900		Supplied by Customer
Special Process	Liquid Penetrant	QSI 038 6.1.1 (ASTM E1417 Level 2)	PO#: 20140501

Inspection Information and Results

Char#	Location	Requirement	Result	UoM	Pass/Fail	Measurement Equipment:	Operation #:
1	D7	1.543±.005	1.542	inch	Pass	Height Gauge	3
2	D6	R.06	R.062	inch	Pass	Radius Gauge	2
3	D6	.30	.304	inch	Pass	Height Gauge	2
4	D6	.500	.500	inch	Pass	Height Gauge	3
5	D6	.38	.380	inch	Pass	Height Gauge	3
6	D5	.030	.030	inch	Pass	Comparator	1
7	C5	.017	.018	inch	Pass	Comparator	1
8	C5	.315	.319	inch	Pass	Height Gauge	2
9	C6	R.031	R.030	inch	Pass	Comparator	1
10	C6	Ø.047	Ø.047	inch	Pass	Gauge Pin	2
11	C6	2.89	2.892	inch	Pass	Vernier Caliper	2

Inspection Information and Results							
Char#	Location	Requirement	Result	UoM	Pass/Fail	Measurement Equipment:	Operation #:
12	C7	Ø.900	Ø.896	inch	Pass	Vernier Caliper	2
13	C7	.63	.625	inch	Pass	Height Gauge	2
14	C7	.050	.054	inch	Pass	Micrometer	2
15	C8	20°	20°	degree	Pass	Comparator	2
16	D8	.090	.093	inch	Pass	Micrometer	2
17	D7	.156	.159	inch	Pass	Comparator	2
18	D7	.450	.446	inch	Pass	Height Gauge	2
19	D4	Ø.250/.249	Ø.249	inch	Pass	Gauge Pin	2
20	D3	Note 6	D4805-5	n/a	Pass	Visual	2
21	D3	.11	.118	inch	Pass	Vernier Caliper	2
22	C4	Ø1.00	Ø1.00	inch	Pass	Vernier Caliper	2
23	B6	Ø.60	Ø.60	inch	Pass	Micrometer	1
24	B5	Ø.420±.000/-.001	Ø.4196	inch	Pass	Micrometer	1
25	A6	1.36	1.359	inch	Pass	Height Gauge	1
26	B6	R.03	R.030	inch	Pass	Comparator	1
27	B4	Ø.60 REF	Ø.60	inch	Pass	Micrometer	1
28	B5	Ø.75	Ø.75	inch	Pass	Comparator	1
29	B3	28.4°	28.4°	degree	Pass	Comparator	3
30	B3	Ø.125	Ø.126	inch	Pass	Height Gauge	3
31	B2	31.6°	31.6°	degree	Pass	Comparator	3
32	B1	Ø.125	Ø.126	inch	Pass	Height Gauge	3
First Article Inspection Report Approved and Completed in Full by:							
				Date: 15-Dec-14			

skyservice Work Order Traveler



Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO23016	Customer: ATG Industries Inc	Dept: NDT YUL	Reference: 20140501
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 6

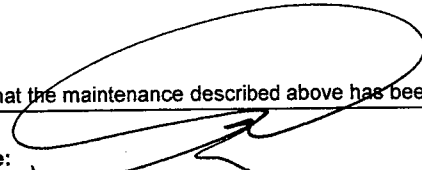

Work Required:

CARRY OUT NDT ON 17 END FITTING P/N D4805-5P AS PER PO: 20140501

Action Taken:		Date:	Initial/Stamp:			
LPI C/O IAW ASTM E-1417M-13 ***NO CRACK FOUND*** PEN.(ZL-37 , B#10A070), DEV.(SKD-S2,B#13D14k) , EMU.(ZR-10B,B#10A074).		DEC 10 2014	 			
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

COPY

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN		DEC 10 2014